

SPLIT

Dart Aerospace Ltd.

Date: Tuesday, 21: 3:45:50 PM
User: Johnston

Process Sheet

Cut er : CU-D 01 Dart Helicopters Services Drawing Name : 100 100 VEL 100 100
Job ber : 25625 2
Esti Num n : 10333
P.C. ipel :
This e : 2/15/02 S.O. No. : NIA Part Number : 100 100
Prs : NC Drawing Number : 100 100
Fire e : NIA Type : SMALL / MED FAB Project Number : 100 100
Prev s Run : 24870 Drawing Revision : 100 100
Material : NIA
Due Date : 2-28-02 Qty: 20 Um: Each
Write By : SEE COMMENT BELOW
Check & Approved By : JLM 06-02-16
Comments : Est Rev: E Removed Purchasing 05-1-07 JLM

Add: 1 P: 1

Job: 100 100



Machine Or Operation:

Description:

1.0 25625A LOCK PLATE



Sub-Component LOCK PLATE

2.0 M304TR0750W049 304 RD Tube .750 x .049W



Content: Qty: 0.4809 f(s)/Unit Total: 9.6180 f(s)
Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall (M304TR0.750W.049)
Batch: 418785 M100738

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Content: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536 SAP 06-02-18

2-Deburr SAP 06-02-18

4.0 D2534 Lock Plate SAP 06-02-22 (P)



Content: Qty: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

QTY Part # Description Batch
2 D2534 Lock Plate B24876A

CPL 06-02-23 (8)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Content: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

CPL 06-02-23 (8) (9)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 25825

Part Number: D2530



Machine Or Operation:

Description:

2-Deburr

QC59

WELD INSPECTION



Comment: WELD INSPECTION

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57183

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



06-03-01

DART

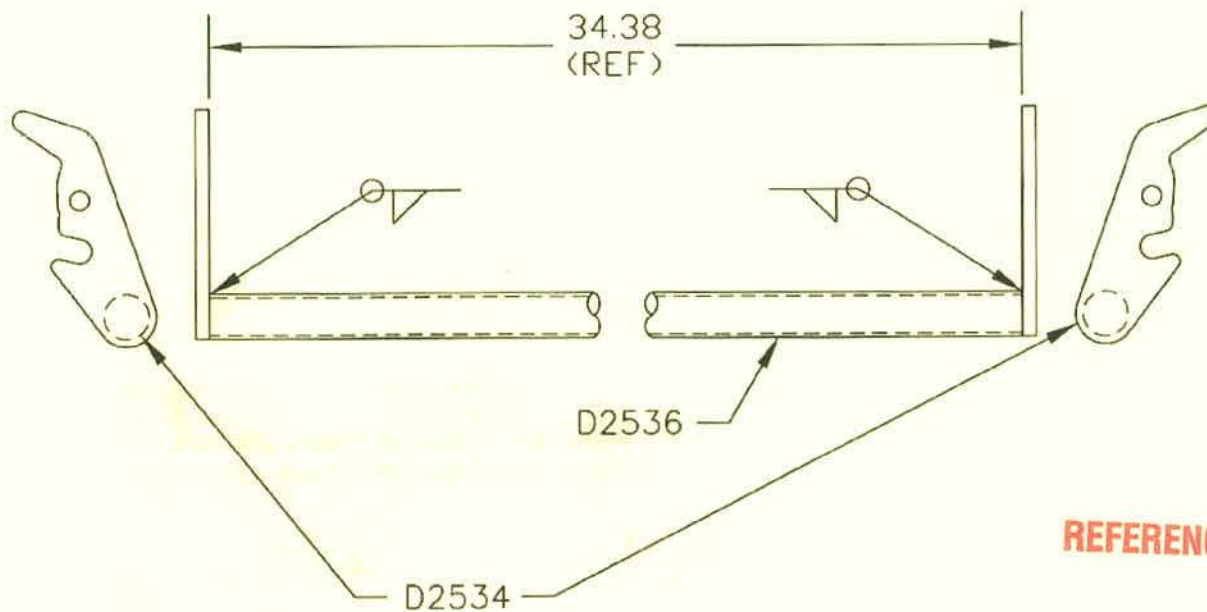
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14	TITLE HANDLE WELDMENT		
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



REFERENCE ONLY

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RECEIVED

1900

1900

1900

1900